

Date: Thursday, 04/12/2008 9:10:45 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)		
Job Number	: 43898		Part Number	: D2573		
Estimate Number	: 10533		Drawing Number	: D2573 REV E		
P.O. Number	:		Project Number	: N/A		
This Issue	: 04/12/2008		Drawing Revision	: E		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 28/12/2008		
Previous Run	: 43566		Qty:	6 Um: Each		
Written By	:					
Checked & Approved By	<u>JLD 08.12.08</u>					
Comment	: Est: 1 As Per RevE 06-01-27 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 7075-T7351 8.25X7.75X2.5 Make from D6101-007 billet for D2573 Ensure that grain is along 7.75" length Batch No: <u>B42991</u> <u>DIP 08/12/08</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program Batch No: <u>43898</u> Double check by: <u>ML</u>	
		1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove sharp edges.	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2573 & D2574	<u>DIP 08/12/08</u> / <u>JL 08/12/10</u>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>JL 08/12/10</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2573 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 08/12/16
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08.12.09	2	TOP RIDGE OF SADDLE, DIM "V" HAS A FLAT ON TOP QUADRANT. MIN DIM IS 0.217". THICKNESS AROUND HOLE UNAFFECTED.	<u>JP</u> 08.12.09 per QSI 042	ACCEPTABLE. ONLY AFFECTS 0.250" RIDGE, NOT HOLE. LANDING LOADS ACT IN OPPOSITE DIRECTION	JL 08/12/09	<u>JP</u> 08.12.09 per QSI 042	<u>JP</u> 08.12.09 per QSI 042	<u>JP</u> 08.12.09

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 08/12/15 (6)

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fx 08/12/15

7.0 POWDER COATING

POWDER COATING



M109152

(6X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 2 = 30

OVEN TEMPERATURE: 320° F

FINISH TIME: 3 = 00

M.F. 08/12/15

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Fx 08/12/15

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST434

JS 08/12/16 (6)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/16 FJ

Job Completion



W 08/12/16

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD				Work Order: 43898	
Description: Saddle, Aft Outboard			Part Number: D2573		
Inspection Dwg: D2573 Rev. E			Page 1 of 1		

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		.502	.501	.505	.502		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.378	0.378	0.378	0.378		
I	0.490	0.510		0.496	.501	.498	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.562	.566	.563	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	4.119	4.129		4.124	4.124	4.124	4.124		
P	0.115	0.135		0.127	0.1265	0.1265	0.125		
Q	0.115	0.135		0.135	.135	.135	.135		
R	0.240	0.260		0.252	0.252	0.252	0.252		
S	0.115	0.135		0.128	.123	.120	.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.228	3.228	3.228	3.230		
V	0.230	0.250		0.238	.239	.217	.236		
W	0.115	0.135		0.133	.129	.123	.125		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.363	.363		
AA	0.470	0.530		0.509	0.500	0.500	0.500		
AB	0.615	0.635		.627	.626	.626	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		0.248	.245	.245	.245		
AE	1.500	1.520		1.511	1.513	1.517	1.516		
AF	0.115	0.135		0.125	.125	.125	.125		
AG	0.240	0.280		0.270	0.270	0.265	0.270		
AH	0.240	0.260		0.250	.250	.246	.247		
AI	2.000	2.020		2.001	2.001	2.004	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	DTT	JK	Audited by:	J.F.
Date:	08/12/08	08/17/05	Date:	08/12/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JK

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AI	2.000	2.020		2.001	2.003				
AJ	0.023	0.043		.033	.033				
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